

1. INTRODUCTION

This instruction sheet contains the procedure required to install AMP mandrels No. 69411-□ and 69551-□ of the modified design. The design was changed to increase the tail length of the mandrel so that it extends over the stabilizer bar on the guide rib inside the tool as shown in Figure 1. Before the mandrel is installed, the stabilizer bar on the guide rib must be filed at an angle as shown. Mandrels of the previous design may also be used in tools with the modified guide rib.

The kind of guide rib (modified or original design) contained in a tool can be determined from the code numbers that are normally placed on the handle of the tool. Generally, if the largest code number is 7441 or greater, the tool contains a guide rib of the modified design. If there is any doubt about whether or not the guide rib was modified, it should be

checked by removing as described in paragraph 2. If desired, the modification can be made by contacting the local AMP field representative.

2. GUIDE RIB MODIFICATION PROCEDURE

- (a) Remove clips from tool.
- (b) Remove insulation ejector. See Figure 2.
- (c) Remove mandrel holding screw and alignment foot from front of tool.
- (d) Remove mandrel.
- (e) Hold tool by handle and push rear of tool completely forward.
- (f) Remove body assembly from front of tool by driving out roll pins. See Figure 3.
- (g) File the stabilizer bar on the guide rib to the dimensions shown in Figure 4.
- (h) Reinstall the body assembly, mandrel, alignment foot, and insulation ejector.

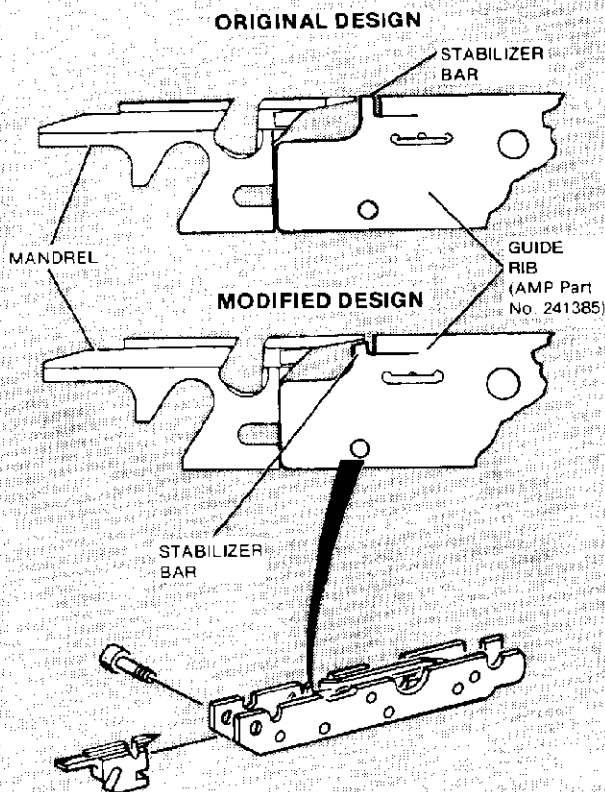


Figure 1

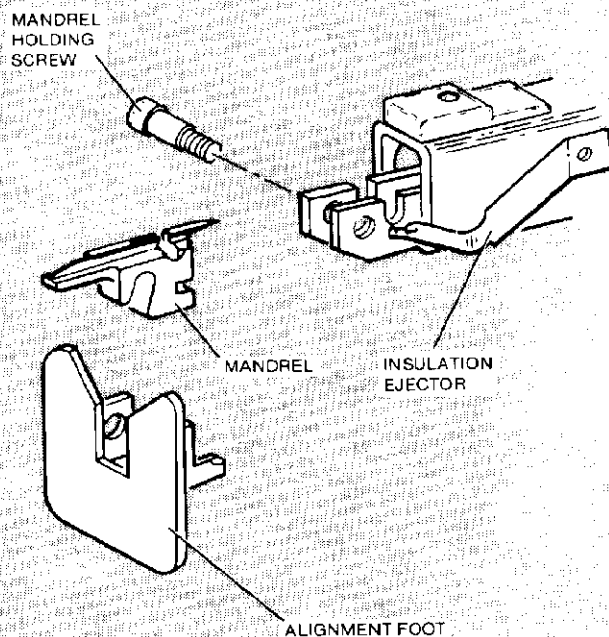


Figure 2

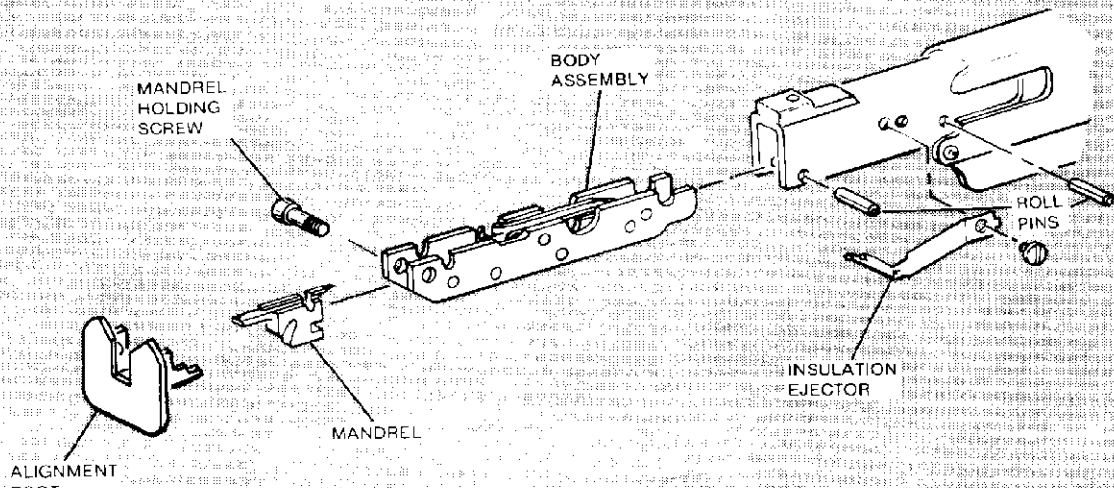


Figure 3

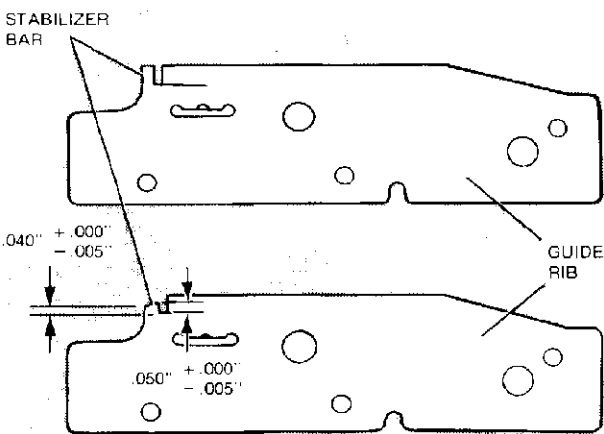


Figure 4